Work Or	der ID	457111
July 14, 2009	7:27:47 A	M

D

Item ID:

120

Packaging

Packaging

**Revision ID:** 

D3186-3



Page 1

Insp.

Stamp

Setup Start

PPD-4810 /59/7/21

Stop Spacepod Door, LH Item Name: Start Qty: 1.00 7/15/09 **Start Date: Cust Item ID:** Required Date: 7/28/09 Req'd Qty: 1.00 **Customer:** Reference: Start Run Tooling: Approvals: Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Reject Work Center ID Description Number Rev. Code Qty Number **Run Hours Qty Draw Nbr Revision Nbr** D3186 Rev D 100 0.00 Small Fab 09-07-20 Small Fab 0.00 Memo Small Fab 1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail) 110 QC5- Inspect part completeness to step on W/O 16/4/20 B C 0.00 Memo Quality Control

0.00

0.00

Identify as per dwg & Stock Location:

Memo

Accept

Dart Aerospa	ice Lt	d
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	•			DI					
W/O:			WC	ORK ORDER CHANG	iES	-			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
<b>18</b>									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
		olution:							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC		· · · · · · · · · · · · · · · · · · ·	tion B	Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
	1								

W	ork	Ord	er ID	45'	711R



Page 2

July 14, 2009 7:27:48 AM

Item ID:

D3186-3

D

**Revision ID:** Item Name:

Spacepod Door, LH

**Start Date:** 

Required Date: 7/28/09

7/15/09

Start Qty: 1.00

Operation

Description

Req'd Qty: 1.00

Accept

**Cust Item ID:** 

**Customer:** 

Setup Start

Stop



Reference:

Approvals:

Sequence ID/

**Work Center ID** 

Process Plan:

QC:

QC21- Final Inspection - Work Order Release

Date: **Tooling:** 

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Draw Number

Draw Rev.

Date:

Date:

Plan Code

Accept Qty

Reject Qty

Start

Stop

Reject Insp. Number

Stamp

130

QC Quality Control

Memo

0.00

0.00

Run

U 29.07.29

# **Dart Aerospace Ltd**

		<del></del>							
W/O:			WO	RK ORDER CHANG	ES			-	
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-						
						<u> </u>			
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Ye	s No <b>DQ</b>	A:	Date: _	
		esolution:	Disposition	:	_ QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sigı Da	1& ∣ <sub>Sect</sub>	tion C	Chief Eng	QC Inspector

July 14, 2009 7:27:47 AM

Work Order ID: 45711B

Parent Item:

D3186-3RevD

Parent Item Name: Spacepod Door, LH

Comments:

**Start Date: 7/15/09** 

Required Date: 7/28/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand

Remaining Qty Qty To Pick Issued Date Issued

Status

D3186-1MRevD

Manufactured

No

Each

0.0000

1.0000

SPACEPOD DOOR LH

45711BOI 8509-0720

Dart .	Aeros	pace	Ltd
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OSPUCC E	.tu							
		WO	RK ORDER CHANG	RES			· · · · · · · · · · · · · · · · · · ·	
STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						1		
•	PAR #:	Fault Categ	jory:	_ NCR: Ye	s No DO	QA:	Date: _	
Res	· · · · · · · · · · · · · · · · · · ·						Date: _	_
		WORK ORDE	R NON-CONFORM	ANCE (NO	CR)			
STED							Approval	Approval
OIL!	Section A	Initial Chief Eng			า&   <sub>Sec</sub>		Chief Eng	QC Inspector
						-		
							<u> </u>	
	STEP	:PAR #: Resolution:	STEP PROCEDURE CHAN  PAR #: Fault Category  Resolution: Disposition  WORK ORDE  STEP Description of NC Section A Initial	WORK ORDER CHANGE  PROCEDURE CHANGE  PROCEDURE CHANGE  PROCEDURE CHANGE  Fault Category:  Disposition:  WORK ORDER NON-CONFORM  STEP  Description of NC Section A  Initial Action Description	STEP PROCEDURE CHANGE By  :PAR #:Fault Category:NCR: Ye  Resolution:Disposition:QA: N/C  WORK ORDER NON-CONFORMANCE (NO  STEP Description of NC Section A   Corrective Action   Section B   Initial   Action Description   Sign	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date  :PAR #:Fault Category:NCR: Yes No DO Resolution:Disposition:QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Verification Section A Section A Section A Section B Section A Section A Section B Section A Section A Section B Section B Sign & Section A Section B Sectio	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty  :PAR #:Fault Category:NCR: Yes No DQA:  Resolution:Disposition:QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #:Fault Category:NCR: Yes No DQA:Date:  Resolution:Disposition:QA: N/C Closed:Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

Qty:

Date: User: Tuesday, 10/02/2009 3:08:28 PM

Julie Dawson

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 45711B

**Estimate Number** 

: 12635

P.O. Number

This Issue

: 10/02/2009

: NC

Prsht Rev. First Issue

Written By

**Previous Run** 

: //

Type

S.O. No. :

: 45692

: SMALL /MED FAB

Checked & Approved By

Comment

07-01-11 EC : Est Rev:A New Issue rev D dwg est rev B

07.03.07 ec

**Process Sheet** 

**Drawing Name** 

: SPACEPOD DOOR LH

**Part Number** 

: D31863

: N/A

**Drawing Number** 

: D3186 REV.D

Project Number **Drawing Revision** 

: D

Material

**Due Date** 

: 05/03/2009

1 Um: Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

SPACEPOD DOOR LH

1.0

45711B01

1 x D3186-1M Batch

Comment: Sub-Component SPACEPOD DOOR LH BOL

**4**t

09 0720

2.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

09-07-20

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace L	_td
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		WO	RK ORDER CHANG	GES					
STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
):	PAR #:	Fault Categ	ory:	_ NCR	: Yes N	No DQ	<b>4</b> :	_ Date: _	
Reso	lution:	Disposition	:	QA:	N/C Clo	sed:		Date:	
		WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
STEP	Description of NC			tion B	C: 0	Verific	ation	Approval	Approval
	Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
							!		
		Resolution:	Resolution: Disposition  WORK ORDE  STEP Description of NC Section A Initial	Resolution:	Resolution:	Resolution: Disposition: QA: N/C Clo  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A	Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Verific Section A Corrective Action Description Sign & Section A Section B Section A Corrective Action Description Sign & Section A Section B Section A Corrective Action Description Sign & Section A Section B Section A Corrective Action Description Sign & Section B	Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Verification Section C Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng.



DESIG		DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
CHECK	ŒD	APPROVED	DRAWING NO.	REV. D
	b	,   AH	D3186 SHE	ET 1 OF 5
DATE	1		TITLE	SCALE
07.0	2.22		SPACEPOD DOOR	NTS
Α		03.03.27	NEW ISSUE	
В		06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
С		06.12.13	REMOVED DOGOO-XXX LABELS	

UPDATE DIMENSIONS

## MAIN LAYUP

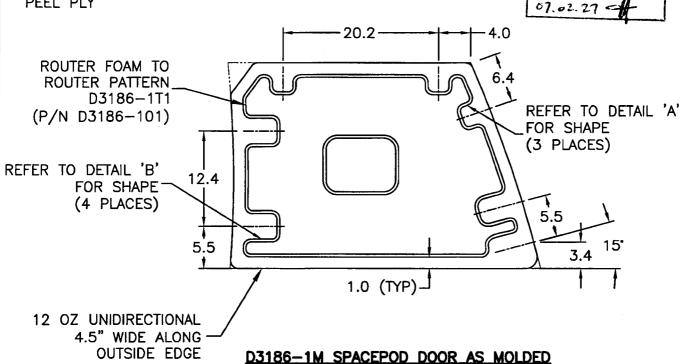
9 OZ SATIN (9 SQ FEET) 9 OZ SATIN (9 SQ FEET)

**FOAM** 

9 OZ SATIN (9 SQ FEET) 12 OZ UNIDIRECTIONAL

9 OZ SATIN (9 SQ FEET) RESIN (35-45% BY WEIGHT) PEEL PLY

RELEASED



07.02.22

D

#### NOTES:

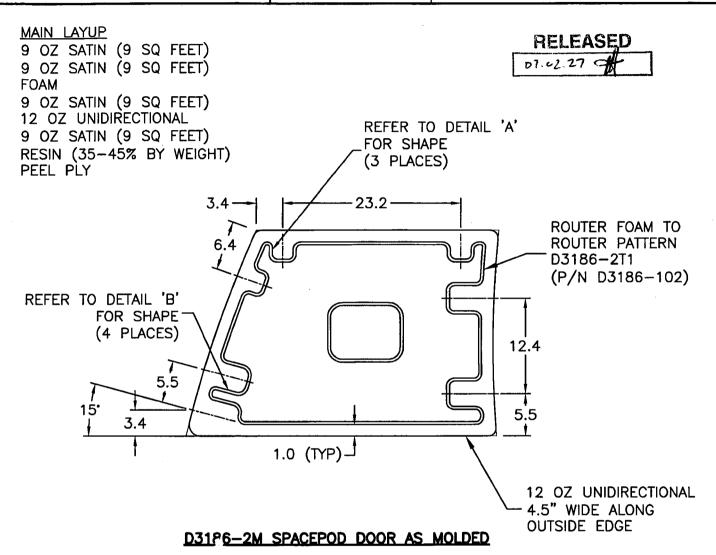
- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL S
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
  - 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN DS	DRAWN BY	DART AEROS HAWKESBURY, ONTA	
CHECKED	APPROVED 11	DRAWING NO.	REV. D
لب	B TO	D3186	SHEET 2 OF 5
DATE	· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
07.02.22		SPACEPOD DOOR	NTS



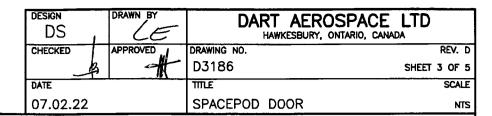
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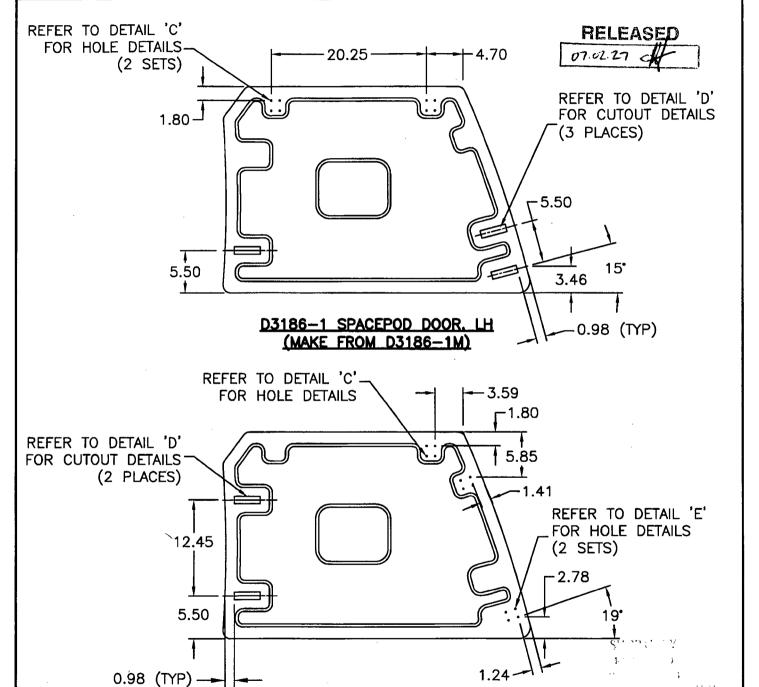
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- EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40 2) RESIN:
- 3) FOAM: 3/8". A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN") 4) FIBRE:
  - 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
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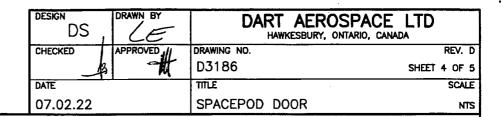
111 457113

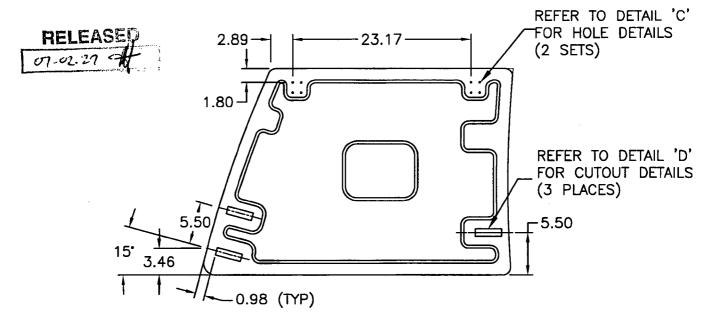
D3186-3 SPACEPOD DOOR, LH (MAKE FROM D3186-1M)

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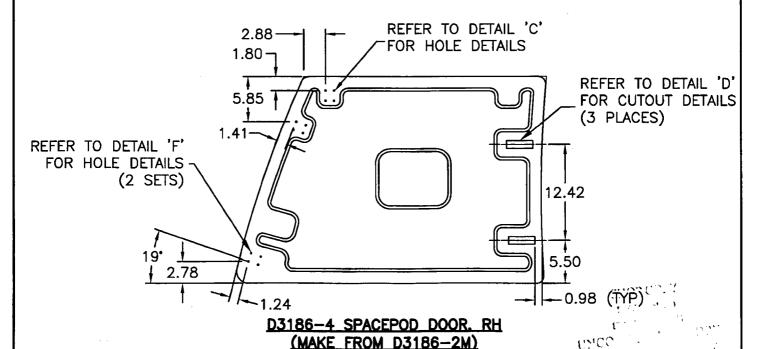
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# D3186-2 SPACEPOD DOOR, RH (MAKE FROM D3186-2M)



#### **NOTES:**

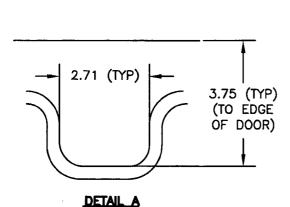
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

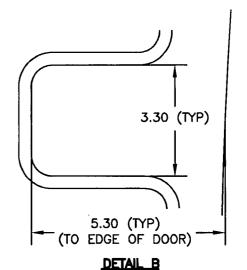
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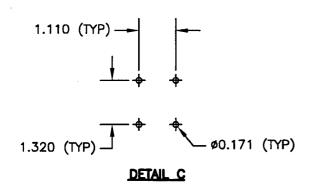


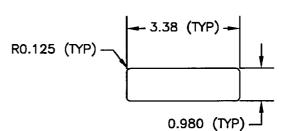
DESIGN DS	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED.	DRAWING NO.	REV. D
1 4	3 4	D3186	SHEET 5 OF 5
DATE		TITLE	SCALE
07.02.22		SPACEPOD DOOR	NTS





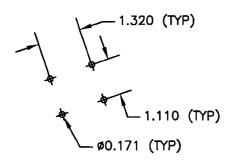
RELEASED 07.02.27

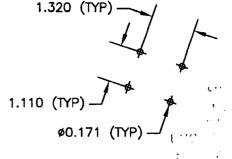




NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

#### DETAIL D





### DETAIL E

# DETAIL

## NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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